Work Orde	er ID 91543 11:27:10 AM	,	*91	543*					Page 1
Item ID: Revision ID:	D350-561-045		Accept	*N900	0401	იი*	Setup Sta	1/1	S1*
Item Name:	Dual Mirror Accessory Installati	ion, 6 inch Round					Sto	^{pp} *N	S2*
Start Date: Required Date:	10/11/12 Start Qty: 1. 10/19/12 Req'd Qty: 1.	•		Cust Item Customer:					
Reference:		•							
Approvals:	Process Plan: 4LJ	•			ate:		Run Sta Sto	17	R1*
	QC:	Date:	SPC (Y/N):	D	ate:			*N	R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool# P	lan Accept Code Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					The state of the s	The transfer of the transfer o		
D350-561	Rev D	452-		ADAC.					
*100 *100* DC	DOCUMENT CO	NTROL	0.00	15 10-3)		H	14	MUT	12-10-30
Document Control	Mem Photo	o copy bluefile and create labels p		CHG003					
105	Pick Kit		0.00						
105 Packaging Packaging	Mem	0	0.00			/_X_			12-10-3
			/ (Ão.					\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\
*110 *11 0 *	QC4- 100% Inspe	ct kits for completeness	0.00	15					
QC Quality Control	Memo	0	0.00	L10-31					

NCR:	Yes /	No				WORK ORDER NON	N-CO	NFOR	MANCE / UP	DATE			•
											QA Closed:	Date	
Work Ord	er:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	· · · · · · · · · · · · · · · · · · ·
Part !				·		Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	otion of work order update	9	Initial	Ac	tion	Sign &		
Cause	Di	ite St	ер	Qty	C	or Non-conformance	c	hief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling								<i>,</i> ·					
Operator			l										
Material													
Setup	Ш												
Other	Ш		}			مو ع	1.3						
Process	Ш					į.	3.						
Supplier							£ 3						
Training													
Unapproved													1
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Landi	ng Gear					General		-			-	_	.
	Bend	•				Bend	-	Grain			Ovalized		Pressure/Forced
		re Not Co	ncent	ric to O	/S	BOM/Route	-	Hardwa		_	Over/Under		Temperature/Cure
	Crac				<u> </u>	Broken/Damaged	\vdash	⊣ '	on Incomplete		Part Incorred	-	Weld
	_	hed/Crim	ped.		 	Burrs	L	⊣	ions Incomplete	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuff				 	Contamination	\vdash	Mainte		ļ	Part Moved		
		Treat			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned V	_	٦٠٠٠
		ection Stri	-	ube		Cut Too Short	· -	Misread	i	<u> </u>	Power Loss/	Surge	Other
		es in Ben			<u> </u>	Drill Holes	<u> </u> -	Offset			-		
	Torq	ue Waves	in Ext	trusion	i	Drawing	1	Out of (Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence
Wave/Twist in Tube

Finish

Folio

Work Order ID 91543 Page 2 October-12-12 11:27:10 AM D350-561-045 Item ID: Accept *N900040100* Setup Start **Revision ID:** Item Name: Dual Mirror Accessory Installation, 6 inch Round Start Qty: 1.00 **Start Date:** 10/11/12 **Cust Item ID:** Required Date: 10/19/12 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Approvals: Tooling: Date: Date: SPC (Y/N): Date: Date: Sequence ID/ Operation **Tool ID** Tool # Plan Reject Reject Set Up/ Accept Insp. **Work Center ID Description** Qty Qty Code Number **Run Hours** Stamp 120 0.00 Packaging *120* Loc_43 Packaging 0.00 Memo Packaging Identify and pack for shipping as per PPP D350-561-045 130 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

Quality Control

N12-11-01

NCR: Y	/es / No				WORK ORDER NON-C	ONE	-OKN	MANCE / UP	DAIL			•
								·		QA Closed:	Dat	e:
Work Orde	or.			·.·	DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	•
	Part No.				Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo		·-··		Work Order Update			Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Ini	tial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	n QC Inspector
Doc/Data					· · · · · · · · · · · · · · · · · · ·							
Equip/Tooling												
Operator												
Material												
Setup												
Other						ŀ						
Process												
Supplier 												
Training	_											
Unapproved			<u>1</u>		E	AULT	CATE	SORV		<u> </u>		
Landir	ng Gear			 	General	TOLI	CATE	JONT				
	Bending				Bend	П	rain			Ovalized	[Pressure/Forced
 	⊣	lot Concer	ntric to C)/S	BOM/Route	\vdash	ardwa	re	-	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged			on Incomplete		Part Incorre		Weld
Ì		/Crimped.			Burrs	\vdash		ions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
Ī	Cuffs	•			Contamination			nance		Part Moved	•	
Ī	Heat Tre	at			Countersink	М	1islabe	led	 	Positioned V	Vrong	
Ī	Inspection	on Strip in	Tube		Cut Too Short	М	lisread	i		Power Loss/	'Surge	Other
Ī	Ripples i	n Bend			Drill Holes		ffset					
	Torque \	Waves in E	xtrusion		Drawing		ut of C	Calibration				
ſ	Turning	Sequence			Finish	0	ut of S	Sequence				

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October-12-12 11:27:09 AM

Work Order ID:

91543

Parent Item:

D350-561-045

10.04.19 verified by:EC

Parent Item Name:

Dual Mirror Accessory Installation, 6 inch Round

Start Date: 10/11/12

Required Date: 10/19/12

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP D05.09.15Step 3 pick list revised per D350-561 Rev.

CKJ/JLM

IPP Rev:E add pick kit DD

IPP Rev:F 10.09.14 per IIN revD DD verf:EC

IPP REV:G 12.05.30 PER ECN 12-596 DD VERF:EC

Component Item ID/ Item _r Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-5A Bolt		Purchased	No			105	Each	1,280.0000	2	2 <	25 ,		8
	~			Location		Loc Oty	<u>L</u>	oc Code			·		
Si	(1)V			ST350		1280							
				115		46							
					423	121							
					355	200							
					187 185	56 6							
					416	500							
					800	351				Da.			
D2011-101		Manufactured	No			105	Each	38.0000	0	, 1	~ ^		
6" Mirror										>	\mathcal{C}_{-}		
5mg	>			Location		Loc Oty	<u>L</u>	oc Code			٥١		
<u>.</u>				ST229		38							
				866	47	38				X			
D2012-113 Clamp		Manufactured	No	-		105	Each	28.0000	2	r\	`		
SW/>				Location		Loc Qty	L	oc Code	Constitution of	A	1800 M		
J1/2				ST003		28							
				841	23 .	28				<u> </u>			
D3635-3 Gasket		Manufactured	No			105	Each	56.0000	2	8	>~	8	
	~			Location		Loc Qty	L	oc Code	W-11-12	<u> </u>		~~~~ ~ {	3 <u>~~</u>
Sm	1 /			ST061		56	_						
				856	56	. 56				2x			
AN960JD10	NAS1149D0363J	Purchased	No	-		105	Each	0.0000	9	4	· /) つ	7.70	
Washer									~		1100	74 X	<i>```</i>

Smo

SP12-10-30.

										DQA:	Date	::
NCR:	Yes / N	0			WORK ORDER NON-O	O	NFORM	MANCE / UPDATE		•		•
										QA Closed:	Date	
Work Ord	or:				DISPOSITION			AGAIN	IST DE	PARTMENT	/PROCESS	`
Part I					Rework Scrap Use-as-is		1	Skid-tube Crosstu Machining Small F noforming Finish	ab	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No				Work Order Update]	B	Large Fab Compos	~		Supplier	
Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material										!		
Setup												
Other												
Process	Ш											
Supplier												
Training												
Unapproved			<u> </u>	<u> </u>		<u> </u>						
					F.	AUL	T CATE	GORY				
Landi	ng Gear				General		,			3	_	
	Bendir	g			Bend	<u> </u>	Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	O/S	BOM/Route		Hardwa	re	<u> </u>	Over/Under	<u> </u>	Temperature/Cure
	Cracks				Broken/Damaged	<u>L</u>	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	$oxed{L}$	Mainte	nance		Part Moved		
	Heat T	reat			Countersink		Mislabe	led		Positioned V	Vrong _	
	Insper	ion Strin in	Tube	[]	Cut Too Short	1	Misread	!		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Octőber-12-12 11:27:09 AM

Work Order ID:	91543								
Parent Item:	D350-561-045						Start	Date: 10/11/12	Required Date: 10/19/12
Parent Item Name:	Dual Mirror Accesse	ory Installation, 6	inch Round				Star	t Qty: 1.00	Required Qty: 1.00
N960JD416 Vasher	NAS1149D0463J	Purchased	No		105	Each	29.0000	2	2m1233555
	~ ~		<u>Location</u>	<u>)n</u>	Loc Oty		Loc Code		-3
•	SM		ST351		29				
				116289	8				
				119097	21			-	·
\$21042L3 t		Purchased	No		105	Each	3,544.0000	2	2012-10-30
			Locatio	<u>on</u>	Loc Qty		Loc Code		
	5W	>	316		701				
				122452	701				
			ST300		338				
				117885	32				
				119017	168				
				119075	138				'
			ST314		1929				_
				123265	1929			- XX	_
			ST317		576			***	
				122141	576				

NCR: Y	'es / No				WORK ORDER NON-	CONF	ORI	MANCE / UP	DATE	QA Closed:	Date	.
					T							•
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work Orac					Rework	7 l		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
,	-	=			Use-as-is] 1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update	J		Large Fab	Composite		Supplier	
Root		T	[Doscri	ption of work order update	Init	tial	Λς.	tion	Sign &		1
Cause	Date	Step	Qty		or Non-conformance	Chief		1	ription	Date	Verification	QC Inspector
Doc/Data	Date	Step	Qty	`	or worr comormance	1		DC361	· iption	Dute	vermeation	Qo mspector
Equip/Tooling		1										
Operator	1	1]		
Material	7	1				1						
Setup												
Other												
rocess		1										
Supplier		1										
Training												
Jnapproved												
					F	AULT (CATE	GORY				
Landin	g Gear				General					7	_	7
	Bending			<u> </u>	Bend		rain			Ovalized	ļ	Pressure/Forced
	Centre No	ot Concer	ntric to (O/S	BOM/Route	_	ardwa			Over/Under	tolerance	Temperature/Cure
Ļ	Cracks				Broken/Damaged	In:	specti	on Incomplete		Part Incorre		Weld
	Crushed/	Crimped.		_	Burrs			ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Ĺ	Cuffs				Contamination	Шм	lainte	nance		Part Moved	:	
Ĺ	Heat Trea	at			Countersink	Шм	islabe	led		Positioned V		- 7
	Inspectio	n Strip in	Tube		Cut Too Short	М	isreac	i		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		ffset					
	Torque W	/aves in E	xtrusion	n [Drawing	0	ut of (Calibration				
	Turning S	equence			Finish		ut of S	Sequence				
	Wave/Tw	ist in Tub	oe .		Folio	O	utside	Dimensions				

DQA:

Date:

DART AEROSPACE LTD.

REFERENCE ONLY

D350-561 Page 14 of 14

5. PARTS LIST

Qty -041	Qty -043	\Qty -045	/ Qty -141	Qty -143	Qty -241	Qty -243	Part Number	Description
X	1						D350-561-041	SINGLE MIRROR INSTALLATION, RH
	Х						D350-561-043	DUAL MIRROR INSTALLATION, RH
	1	Х		1		1	D350-561-045	MIRROR KIT
			X	1			D350-561-141	SINGLE MIRROR INSTALLATION, RH
				Х			D350-561-143	DUAL MIRROR INSTALLATION, RH
					X	1	D350-561-241	SINGLE MIRROR INSTALLATION, LH
						Х	D350-561-243	DUAL MIRROR INSTALLATION, LH
1		1	1		1		D2011-101	-Mirror
1			•	<u> </u>	<u> </u>		D2012-101	Arm
1					ļ		D2012-103	Arm
1			1				D2012-105	Arm
					1		D2012-106	Arm
2			1		1		D2012-107	Clevis
1							D2012-109	Bracket
1			1		1		D2012-111	Bracket
4		12					D2012-113	Clamp
1			1		1		D2012-115	Bracket
4			2		2		D2022-101	Spacer
4							D2856-100-325	Abrasion Strip
1*		1*	1*		1*		D3014-1	Locknut
		L	1		1		D3629-1	Bracket
			1		1		D3635-1	Gasket
		/ 2					D3635-3	Gasket
			1				D3646-1	Arm
				ļ	1		D3646-2	Arm
		ļ	11				D3646-3	Arm
					1		D3646-4	Arm
			2		2		D4070-041	Clamp
2							-AN3-4A	Bolt
2		[2	6		6		-AN3-5A	Bolt
1		ļ	1		11	ļ	AN3-6A	Bolt
2		ļ	1		1		AN4-10A	Bolt
3			3		3		AN4:5A	-Bolt
14		54	8		8		AN960JD10	Washer
9		12	8		8		AN960JD416	Washer
1*		ly*	1*		1*		CAN960JD416L	Washer
5		[2	4		4	ļ	MS21042L3	_Nút (or MS21042-3)
5			4		4		MS21042L4	Nut (or MS21042-4)

*INCLUDED AS PART OF D2011-101 MIRROR